

SHIP AUG 4 - AIRBUS

Work Order ID 162708

162708

Page 1

Friday, June 09, 2017 9:05:00 AM

Item ID: D350-591-113 Accept *N9000040100* *Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access Step, Short, High Gear
 Start Date: 6/9/2017 Start Qty: 4.00 *4* 3 DAS 21 9-89
 Required Date: 7/4/2017 Req'd Qty: 4.00 *4*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2310	D								
DSI 9525	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-591-113		CHG005						
110	Large Fab	0.00							
110	Large Fab	1.20							
Large Fab	Memo								
Large Fab	1-Cut D2244 extrusion to 62.00" long as per Dwg D2310								
	2-Drill extrusion as per Dwg D2310 using drill Jig DT8230								
	3-Deburr								

3 DAS 28 9-89 AUG 02 2017

4x D.M.L 2017-06-15
 4x DC 2017-06-15

162708

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/9/2017 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/4/2017 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 162708

Friday, June 09, 2017 9:05:00 AM

162708

Page 3

Item ID: D350-591-113 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access Step, Short, High Gear
Start Date: 6/9/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>136158</u> Large Fab	0.00				<u>4</u>		<u>JUN 26 2017</u>	DAS 24 9-89
	Memo	1.12							
Large Fab	1-Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: <u>136158</u> 2-Grind end cap and bottom bushing welds flush								
132 *132* Mill Conv	Manufacture as per dwg	0.00				<u>4</u>	<u>0</u>		DAS 32 9-89 <u>17-07-07</u>
Conventional Milling Machine	Memo	0.78							
	Machine top weld on bushing flush as per dwg.								
140 *140* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
Quality Control	Memo	0.00				<u>0</u>	<u>17-07-07</u>		

Page 4

PTC

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>162708</u> Part No. <u>10350-591-113</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☒</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☒	Composite	☐	Supplier	☐																																																																																																
Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐																																																																																																																																
Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐																																																																																																																																
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐																																																																																																																																
Large Fab	☒	Composite	☐	Supplier	☐																																																																																																																																		
Date: <u>17-07-26</u>		Step #: <u>170</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval <u>5.7.16.7.26</u>																																																																																																																																
Description Work Order Deviation				Disposition																																																																																																																																			
D2275 BUSHING IN STEP IS TO LOOSE WITH CHAMFERS. MAKES PIN-HOLES AND CRACKS. RE. PROCESS of manufacturing				SCRAP NO REPLACE				Completed By <u>38</u> <u>9-89</u> <u>1111 26 2017</u> Lead hand / Supervisor Approval Verification <u>JUL 26 2017</u> DAS <u>24</u> <u>9-89</u> QC / QA Coordinator Approval <u>DAS</u> <u>38</u> <u>9-89</u> <u>JUL 26 2017</u>																																																																																																																															
Root Cause <table border="0"> <tr> <td>Environment</td><td>☐</td> <td>No Re-verification</td><td>☐</td> </tr> <tr> <td>Design</td><td>☒</td> <td>Operator</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </table>		Environment	☐	No Re-verification	☐	Design	☒	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table border="0"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Temperature/Cure</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Set-up</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Centre Not Concentric</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☒</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Inspection Incomplete/Unqualified</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Cuffs</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>Countersink</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Heat Treat</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Wave/Twist in Tube</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> </table>						Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Cracks	☒	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Environment	☐	No Re-verification	☐																																																																																																																																				
Design	☒	Operator	☐																																																																																																																																				
Doc/Data	☐	Offset/Setup	☐																																																																																																																																				
Equip/Tooling	☐	Supplier	☐																																																																																																																																				
Handling/Pre	☐	Training	☐																																																																																																																																				
Material	☐	Use for Testing	☐																																																																																																																																				
Internal Transport	☐	Poor Information	☐																																																																																																																																				
Tribal Knowledge	☐	Rushing	☐																																																																																																																																				
LOA	☐	Product Improvement	☐																																																																																																																																				
Substation	☐	Process Improvement	☐																																																																																																																																				
Past Expiry Date	☐	Manufacturing Process	☐																																																																																																																																				
Misidentified	☐	Past Due	☐																																																																																																																																				
Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																
Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐																																																																																																																																
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐																																																																																																																																
Cracks	☒	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐																																																																																																																																
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																																
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐																																																																																																																																
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐																																																																																																																																
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐																																																																																																																																
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																
OTHER: ☐																																																																																																																																							

162708

Friday, June 09, 2017 9:05:00 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/9/2017 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/4/2017 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

Work Order ID 162708

Friday, June 09, 2017 9:05:00 AM

162708

Page 6

Item ID: D350-591-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access Step, Short, High Gear
 Start Date: 6/9/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/4/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 188014.</i> Memo <i>8:20</i> START TIME: <i>320°</i> OVEN TEMPERATURE: <i>8:30</i> FINISH TIME: <i>8:30</i>	0.00 0.73				<i>3</i>	<i>0</i>	<i>170728.888</i>	
220 *220* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M 1379470</i> Memo ***Install Dart labels after wing walk***	1.07						<i>x3 of 14/62/3</i>	
230 *230* QC Quality Control	QC3- Inspect Part Finish Memo ***Install Dart labels after wing walk***	0.00 0.04				<i>3</i>		<i>38</i> <i>9-89</i>	<i>AUG 01 2017</i>

Work Order ID 162708

Friday, June 09, 2017 9:05:00 AM

162708

Page 7

Item ID: D350-591-113 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access Step, Short, High Gear
Start Date: 6/9/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Pick Kit	0.00							
240									
Packaging	Memo	0.04							
Packaging									
250	QC4- 100% Inspect kits for completeness	0.00							
250									
QC	Memo	0.12							
Quality Control									
260	Identify as per dwg & Stock Location:	0.00							
260	PACKAGING RESOURCE #1								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-113 Location: _____								

3 DAS 6 9-89 AUG 01 2017

3 DAS 28 9-89 AUG 02 2017

3x DAS 28 9-89 AUG 02 2017

Work Order ID 162708

Friday, June 09, 2017 9:05:00 AM

162708

Page 8

Item ID: D350-591-113 Accept ***N900040100*** Setup Start ***NS1***
Revision ID:
Item Name: Heli-Access Step, Short, High Gear Stop ***NS2***

Start Date: 6/9/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/4/2017 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-88		AUG 02 2017
270 QC	Memo	0.40							
Quality Control									

DAS
21
9-88

AUG 02 2017

Picklist Print

Friday, June 09, 2017 9:04:58 AM

Page 1

Work Order ID: 162708

162708

Parent Item: D350-591-113

D350-591-113

Parent Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/9/2017

Required Date: 7/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:H04.11.09ReformatKJ/JLM
ECN10-586 10.06.18 DD verf:EC

IPP Rev:E as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116 *D2244-116* Step Extrusion		Manufactured	No			110	Each	60.5000	1	4			
** 4 D.M.L 2017-06-15													

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA003	60.4999632	
	150064	60.5	
D2275 *D2275* Bushing	Manufactured	No	
** 4 JUN 26 2017 DAS 24 9-89			

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA003	9	
	154822	9	
D2582 *D2582* Hi-Skid Step Leg Assembly	Manufactured	No	
** 4 JUN 26 2017 DAS 24 9-89			

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA003	12	
	157228	3	
	159028	9	
D2673-34 *D2673-34* End Plate	Manufactured	No	
** 8 JUN 26 2017 DAS 24 9-89 (for replacement)			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA003	117	
160473	117	

~~8~~ 8

Picklist Print

Friday, June 09, 2017 9:04:59 AM

Page 2

Work Order ID: 162708

162708

Parent Item: D350-591-113

D350-591-113

Parent Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/9/2017

Required Date: 7/4/2017

Start Qty: 4.00

Required Qty: 4.00

K591-113

Manufactured No

240

Each

0.0000

1

4

K591-113

Short Step Installation

MS20600-AD4W3

Purchased No

170

Each

464.0000

16

64

MS20600-AD4W3

Cherry Rivet

**

162709

AUG 01 2017 DAS 6

**

X

Location

Loc Qty

Loc Code

CCK004

300

m137412

300

ST308

104

m135603

104

WA003

60

m136648

60

X32 S.C 2017.07.17

X32 S.C 2017.07.17

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

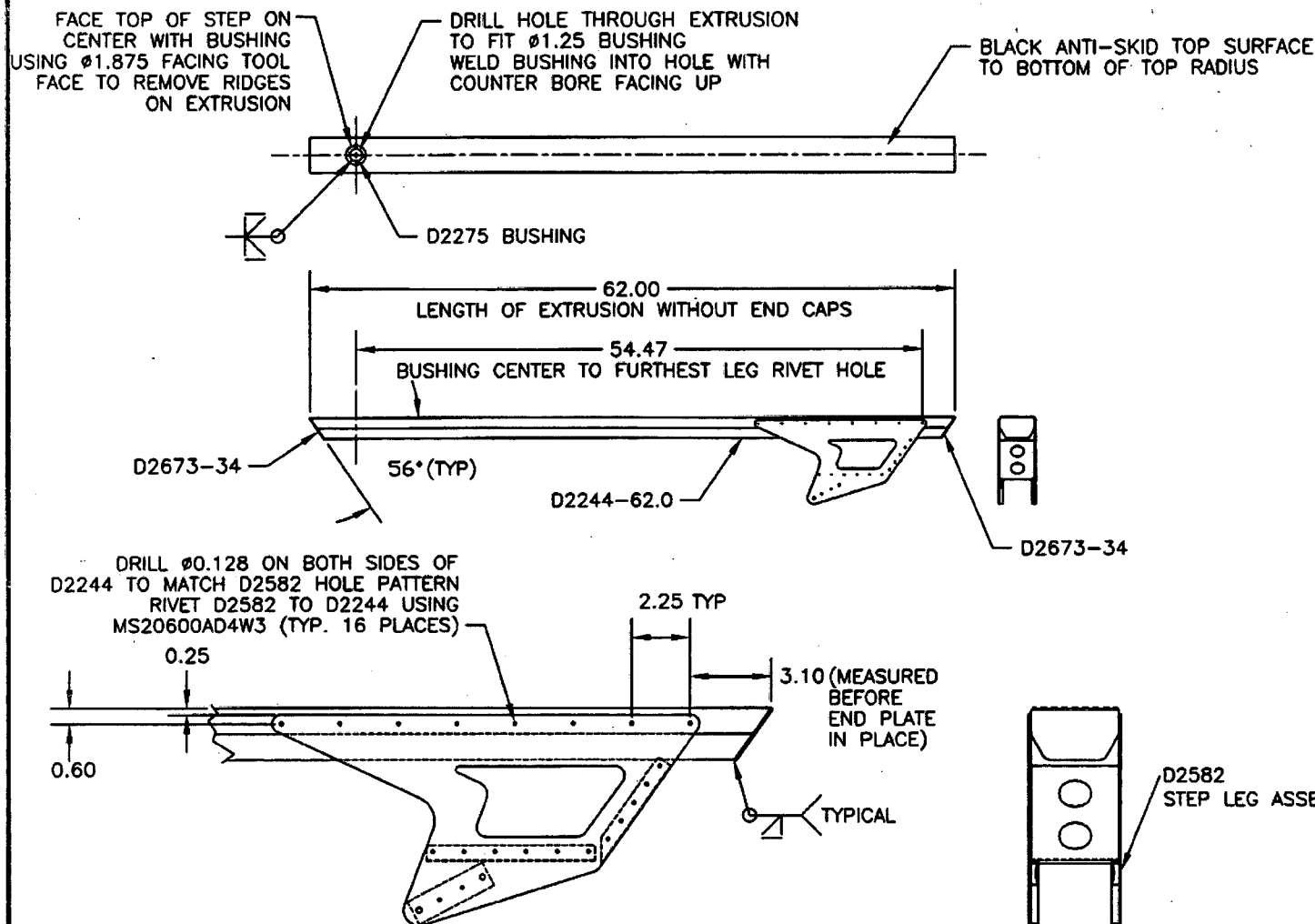
*cut per drawing

*all 62200***RELEASED**
05.11.28**Copyright © 1994 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2310	REV. D
DATE 05.11.14	TITLE HIGH SHORT STEP ASSEMBLY	SHEET 2 OF 2	SCALE NTS



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.4.28

SHIP AUG 4 - AIRBUS

Work Order ID 162708

Friday, June 09, 2017 9:05:00 AM

162708

Page 1

Item ID: D350-591-113

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/9/2017 Start Qty: 4.00

Required Date: 7/4/2017 Req'd Qty: 4.00

4 3
4

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: V Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2310	D
DSI 9525	A

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo 0.00

Photocopy bluefile & type labels per PPP D350-591-113 CHG005

DAS
21
9-88

AUG 12 2017

3

110 Large Fab 0.00

110

Large Fab

Large Fab

Large Fab

Memo 1.20

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
3-Deburr

4x D.M.L. 2017-06-15

4x DC 2017-06-15